



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3066-1
Job Sheet 170513



Part No: D3066-1

Job Qty: 60 ea

Part Name: Spacer



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/16/18

Job Tracking No:

Due Date: 2/2/18

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV B IPP: C 02.11.01 Incorporated D3066-1 IPP KJ/RF IPP Rev:B Now M6061-T6 06-06-23 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	60 Ea	2/1/18	2/1/18	0.00	0.00	Start Up Waterjet		OK 18/01/28
100	Waterjet	60 pcs	2/1/18	2/1/18	0.00	2.13	Waterjet1		OK 18/01/28
120	QC	60 pcs	2/1/18	2/1/18	0.00	0.00	QC8		OK 18/01/28
130	HandFinish	60 pcs	2/2/18	2/2/18	0.00	0.92	HandFinish1		2018/01/30 JLM
140	QC	60 pcs	2/2/18	2/2/18	0.00	0.00	QC7-2		11 JAN 31 2018
150	Packaging	60 pcs	2/2/18	2/2/18	0.00	0.00	Packaging3	WA003	OK 18/01/28
160	QC21-SA	60 Ea	2/2/18	2/2/18	0.00	0.00	QC21		OK 18/01/28

Part Op 100 - 1-Cut as per Dwg D3066
Descriptions: 150 - *** STOCK IN STEP CELL***

FEB 01 2018

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6S.080	6	254	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Spacer	0.128inches + 0.005 - 0.000	0.133 0.128		
2	Spacer	0.708inches ± 0.010	0.718 0.698		
3	Spacer	0.354inches ± 0.010	0.364 0.344		
4	Spacer	0.354inches ± 0.010	0.364 0.344		
5	Spacer	2.250inches ± 0.005	2.255 2.245		
6	Spacer	16.450inches ± 0.010	16.460 16.440		
7	Spacer	0.080inches ± 0.010	0.090 0.070		

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐



Work Order: _____		DISPOSITION			
Part No. _____		Rework ☐		Skid ☐	
NCR No. _____		Scrap ☐		Mac ☐	
Date: _____		Use-as-is ☐		Thermof ☐	
Step #: _____		Suspected Unapproved ☐		Lai ☐	
Description Work Order Deviation					
Q7					
Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com					
DART AEROSPACE S036202 Spacer					
PART NO: D3066 - 1 Original Serial #: S036202 Revision: Operation: Change No:					
Start up Operation 01/28/18 Job No: 170513					
erling ☐ uality ☐ Other ☐					
042) Approval					
Completed By					
and / Supervisor oval Verification					
/ QA Coordinator Approval					
Positioned Wrong Outside Dimensions Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Drawing Finish Misread Turning Sequence					
Fit/Function ☐ Misaligned/off center ☐					
Root Cause					
Environment		No Re-verification		Pressure/Forced	
Design		Operator		Bending	
Doc/Data		Offset/Setup		Centre Not Concentric	
Equip/Tooling		Supplier		Cracks	
Handling/Pre		Training		Crimp/Kink/Ripple/Wave	
Material		Use for Testing		Cuffs	
Internal Transport		Poor Information		Crushing	
Tribal Knowledge		Rushing		Heat Treat	
LOA		Product Improvement		Wave/Twist in Tube	
Substation		Process Improvement		Marks/Chatter	
Past Expiry Date		Manufacturing Process		OTHER: ☐	
Misidentified		Past Due			